

00000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 09, 2005
11:26 am

Work Order No	: 0024000	Department Code:	
Project Name	: pB67-43001-213 ✓	Burden Flags	: NNNNNNN
Project For	: WK538	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: pB67-43001-213	Invoice Number	:
Description	: Flanged Hook	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 38	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-09-05	Est Margin	: 0.000%
Est Finish Date	:	Actual Margin	: 0.000%
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 05/08/17

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

5/38

DART AEROSPACE LTD	Work Order:	24000
Description: Flanged Hook	Part Number:	B67-43001-213
Dwg: B67-43001 Rev. B page 17	Qty:	38 40
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.08.12	38
2	MV	Cut blanks: 2.00" x 1.00" x 2.750" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.000x02.000) Identify for B67-43001-213 Batch: <u>M17365</u>	7m	05/08/14	40
3	MV	Machine as per Folio FA531 and Dwg B67-43001 Identify as B67-43001-213 Dwg Rev <u>B</u> Folio Rev <u>B</u>	7m	05/08/15	40
4	QC2	Inspect parts as they come off the CNC machine	7m	05/08/15	40
5	QC8	Second check	E	05.08.15	40
6	MV	Deburr	7m	05/08/15	40
7	ST	Identify and Stock	CL	05/08/16	40
8	AC	Cost / part: <u>7.42</u>	545	05.08.17	40
9	DC	Close W/O <u>11.90</u> Inspect Level 21	D	05/08/17	40

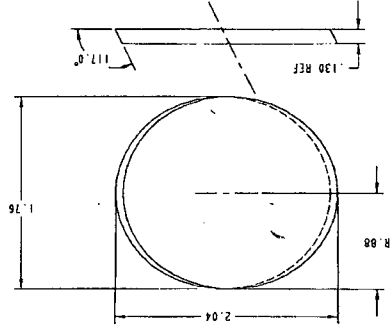
Rev	Date	Change	Revised By	Approved
A	05.06.08	New issue	KJ/JLM	

RELEASED
05/05/08

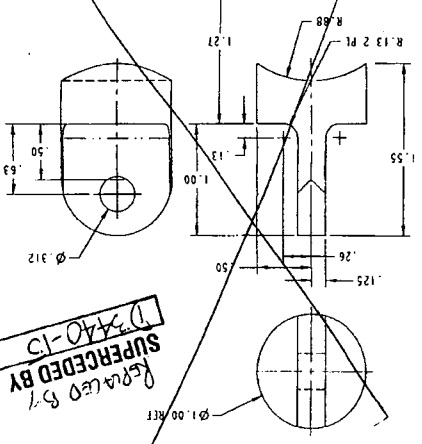
ORIGINAL

PREMIER AVIATION, INC.
1171 CODE 0000
B67-43001
SCALE 1:1
REV. 17 OF 45

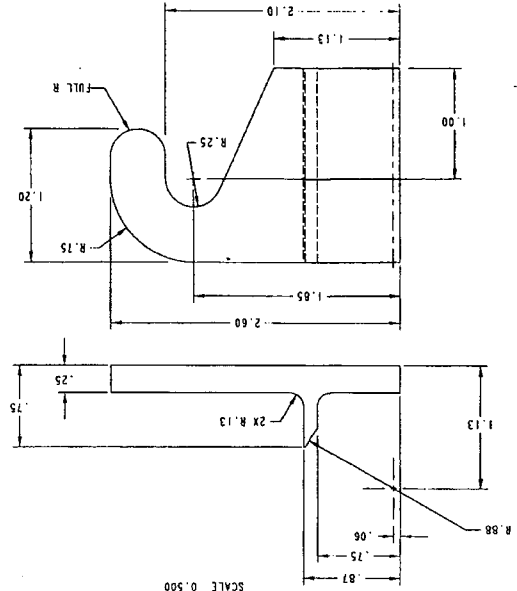
②
-199 OUTER TUBE END CAP
MATERIAL: 1.25 THK. 6061-T6
SCALE 2:000



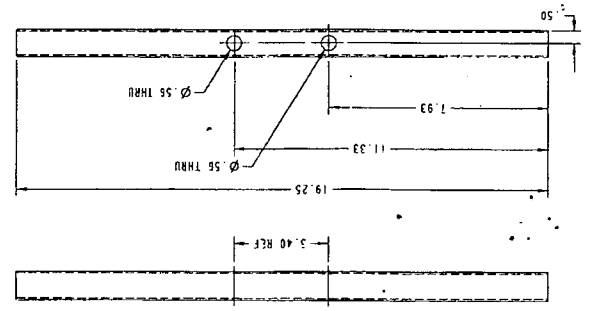
①
-215 CONTOURED MALE EYE
MATERIAL: 1.00 RND. 6061-T6
SCALE 2:000



②
-213 FLANGED HOOK
MATERIAL: 6061-T6 00-A-20078
SCALE 2:000

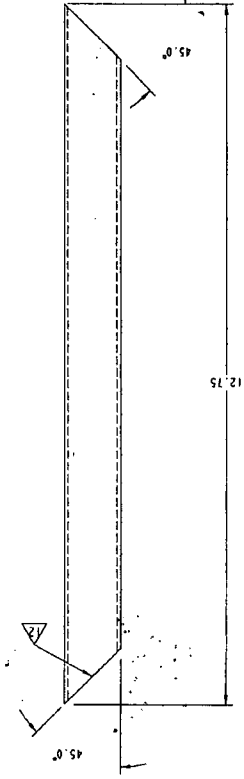


②
-203 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL. 6061-T6
SCALE 0:500

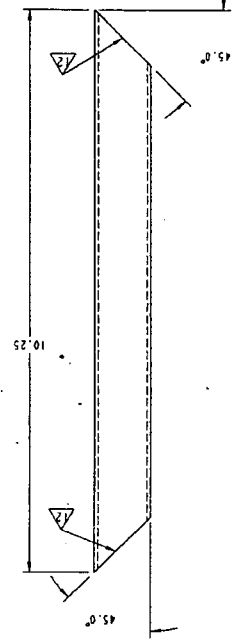


REFERENCE ONLY

②
-211 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL. 6061-T6
SCALE 1:000



②
-209 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL. 6061-T6
SCALE 1:000



RELEASED
#00 of 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:32:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGED HOOK

Job Number: 40040

Part Number: PB6743001213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Pat E.

mf 08 - 07 - 09

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/09

Job Completion



mf 08 - 07 - 09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:32:53 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLANGED HOOK
Job Number :	40040		
Estimate Number :	12066		
P.O. Number :		Part Number :	PB6743001213
This Issue :	24/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 PAGE17
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	B1
	Type :	Material :	
	MACHINED PARTS	Due Date :	01/07/2008
Written By :		Qty:	10
Checked & Approved By :	<u>MLF 08-06-24</u>	Um:	Each
Comment :	Est. A05.06.08 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.2516 f(s)/Unit Total: 2.5158 f(s)
 6061-T6 Bar 1.0" x 2.0"
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 M6061T6B1.000x02.000
 Identify for B67-43001-213
 Batch: M104187

JL 08/06/25 (10)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.00" x 1.00" x 2.750" long

JL 08/06/25 (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA531 and Dwg B67-43001
 Identify as B67-43001-213
 Dwg Rev B1
 Folio Rev AA

ML 08/06/27 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

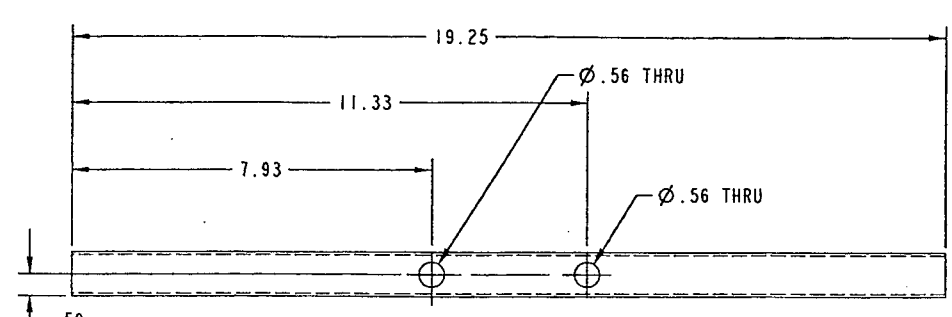
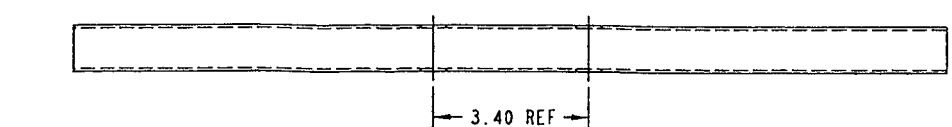
ML 08/06/27 (10)

5.0	QC8	SECOND CHECK
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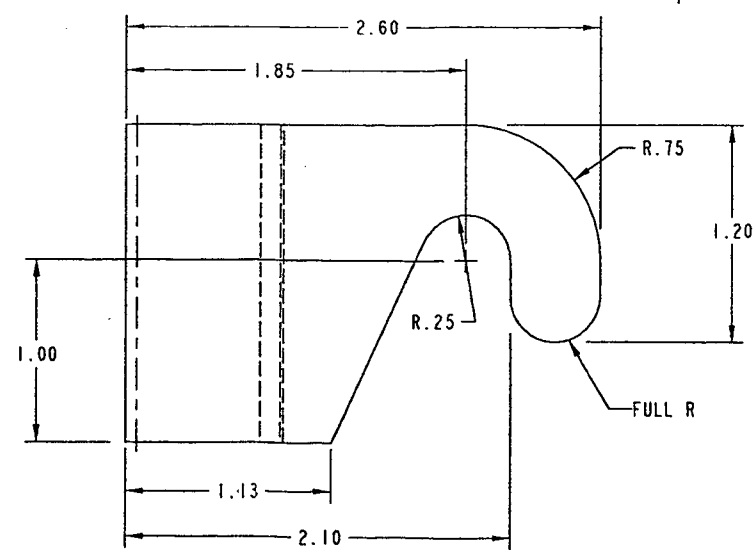
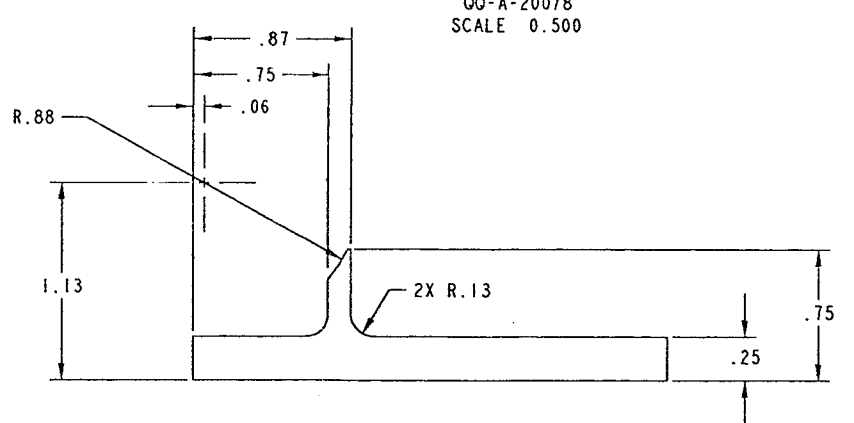


Comment: SECOND CHECK

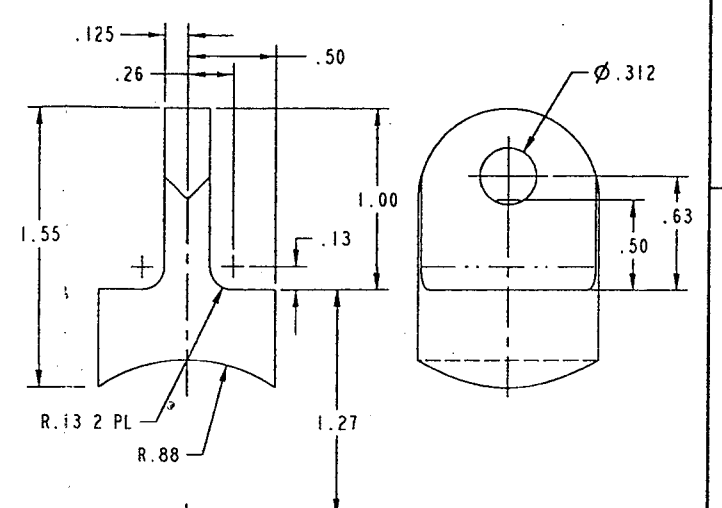
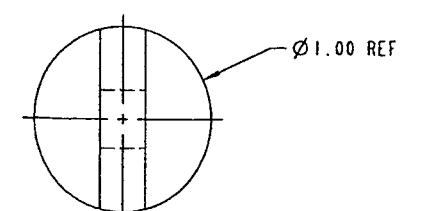
S 08/07/01 (x10)



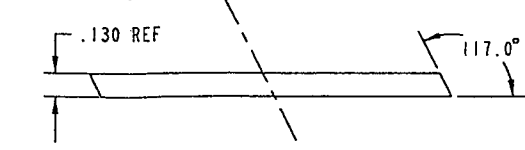
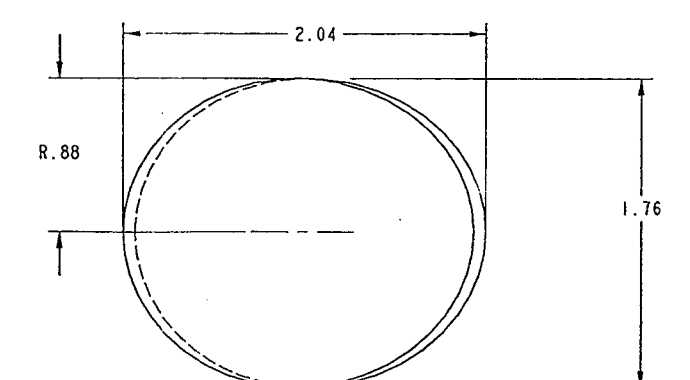
② -203 SQUARE TUBE
 MATL: 1.00 SQ X .065 WALL, 6061-T6
 QQ-A-200/8
 SCALE 0.500



② -213 FLANGED HOOK
 MATL: 6061-T6 QQ-A-200/8
 SCALE 2.000



① -215 CONTOURED MALE EYE
 MATL: 1.00 RND, 6061-T6
 QQ-A-200/8
 SCALE 2.000



② -199 OUTER TUBE END CAP
 MATL: .125 THK, 6061-T6
 QQ-A-250/11
 SCALE 2.000

SHOP COPY
 RETURN TO
 ENGINEERING

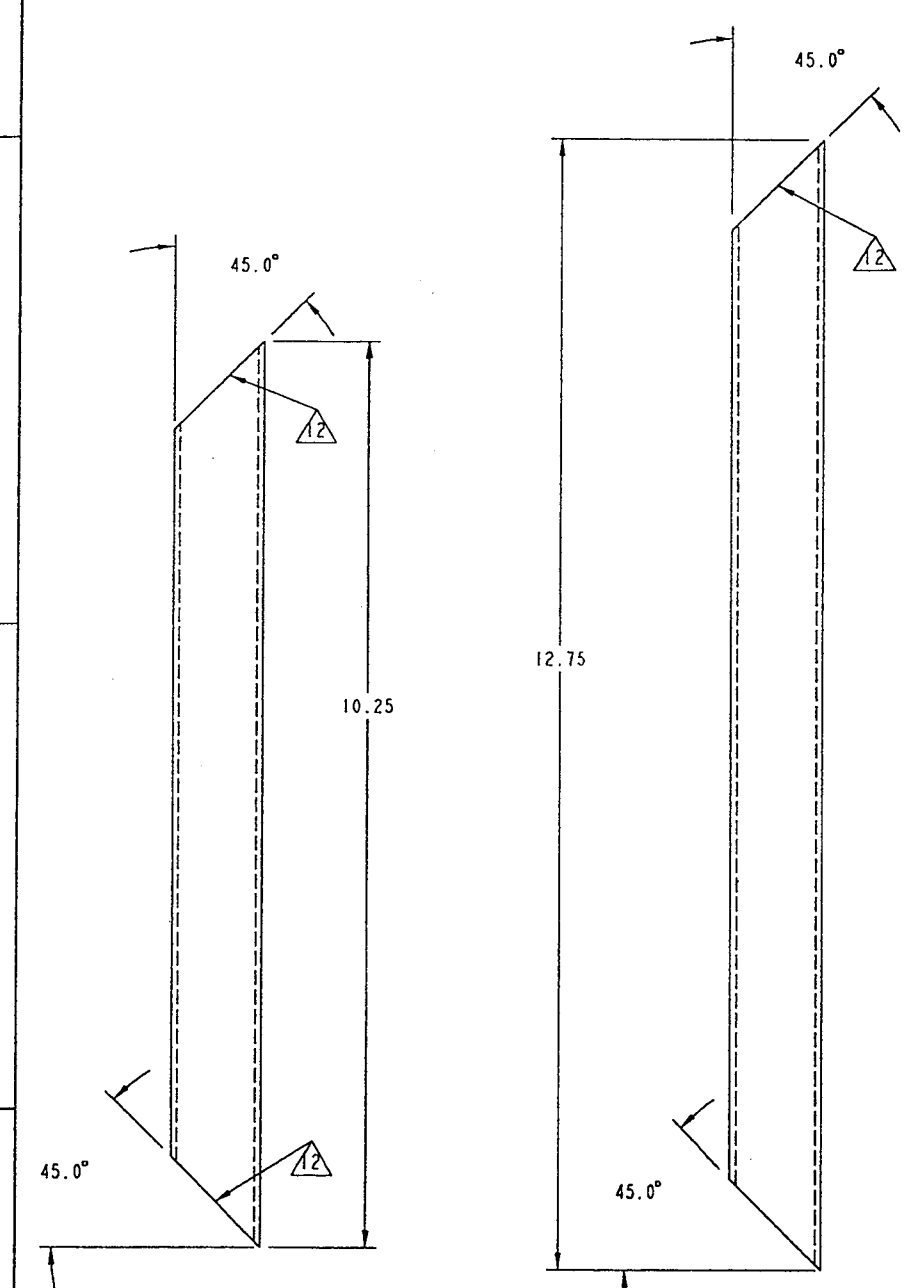
UNCONTROLLED COPY

TO AMENDMENT
 WITHOUT NOTICE

WORK ORDER
 NO. 24000

PREMIER AVIATION, INC.			
2021 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	IDENT NO.	REV.
D	OSUV8	B67-43001	B
SCALE:	WT:	SHEET	17 OF 45

ORIGINAL



② -209 SQUARE TUBE
 MATL: 1.00 SQ X .065 WALL, 6061-T6
 QQ-A-200/8
 SCALE 1.000

② -211 SQUARE TUBE
 MATL: 1.00 SQ X .065 WALL, 6061-T6
 QQ-A-200/8
 SCALE 1.000